



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3490-3**Job Sheet 194942****Part No:** D3490-3**Job Qty:** 40 pcs**Part Name:** Cross Bolt Spacer**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/10/19**Job Tracking No:****Due Date:** 5/24/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV A IPP Rev:A New Issue 06-03-03 JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Lead Time	Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier		
100	Hardinge - 1	40 pcs		5/24/19	0.00 2.00	Hardinge - 1		JBD 19/06/19
120	QC 8	40 pcs		5/24/19	0.00 0.00	QC 8 - 12		GML 19/06/18
						QC 8 - 14		
						QC 8 - 17		
						QC 8 - 20		
						QC 8 - 25		
						QC 8 - 3		
						QC 8 - 32		
						QC 8 - 33		
						QC 8 - 35		
						QC 8 - 39		
						QC 8 - 4		
						QC 8 - 44		
						QC 8 - 45		
						QC 8 - 49		
						QC 8 - 58		
						QC 8 - 8		
						QC 8 - 9		
						QC 8 - 68		
						QC 8 - 67		
						QC 8 - 1 (A)		
						QC 8 - 47		
						QC 8 - 40		
						QC 8 - 52		
						QC 8 - 23		
124	Handfinish - 4-1-Assembly-B4B	40 pcs		5/24/19	0.00 0.67	Handfinish - 4 - 1 - B4B		
						Handfinish - 4 - 10 - B4B		
						Handfinish - 4 - 11 - B4B		
						Handfinish - 4 - 12 -		

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				B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	BE
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
130 Packaging 3-1 - Stock - B4B	40 pcs	5/24/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BE
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	40 pcs	5/24/19	0.00 0.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	21
				QC 21 - SA - 53	21

Part Op 100 - Hardinge - 1-TURN AS PER FOLIO FA629 & DWG D3490

Descriptions: 120 - QC8- Inspect parts - second check)

124 - Assemble as per dwg - CLEAN CROSSBOLT SPACER WITH ALUMINUM CLEANER

130 - Identify as per dwg & Stock Location: 2601 ***STOCK IN SKIDTUBE CELL ***

140 - QC21- Final Inspection - Work Order Release

JUN 17 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.750	6061-T6 Round Bar .750"	10.6400 ft (.266 ea)	100-Hardinge - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6R0.750	11	64	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crossbolt Spacer	3.085inches + 0.030 - 0.000	3.115 3.085		
2	Crossbolt Spacer	0.080inches ± 0.010	0.090 0.070		
3	Crossbolt Spacer	0.050inches ± 0.010	0.060 0.040		
4	Crossbolt Spacer	45.0Degrees ± 0.0	0.0 0.0		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details: _____					



Container No: S188611



Part: D3490-3

Job No: 194942

Serial No/Batch: S188611

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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